

Owner's  
Operation Manual  
Addendum for  
6500 XT



***Please read the SEAL<sup>®</sup> Image<sup>®</sup> 6500 Owner's Manual for the basic operating procedures before using this addendum.***



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## INTRODUCTION

The purpose of this addendum is to outline the differences in operation and features of the SEAL® Image® 6500 XT laminator in addition to the SEAL Image 6500 laminator model.

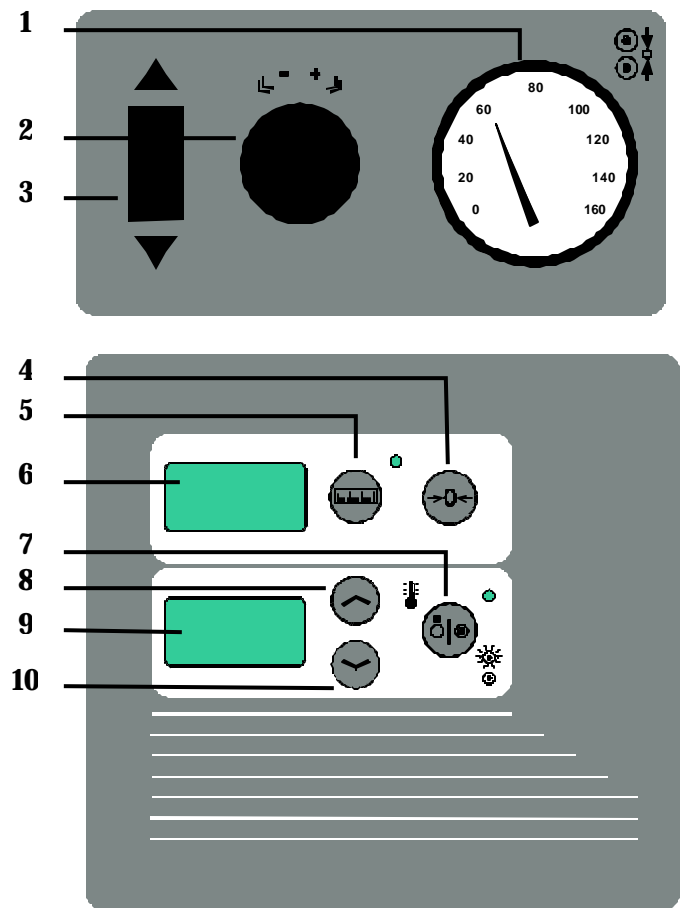
***IMPORTANT! All information regarding WARNINGS and Safety Information contained in the SEAL Image 6500 Owner's Manual is valid for the operation of the SEAL Image 6500 XT laminator.***

### **6500 XT Additional Features:**

- Higher temperature and transfer capabilities (300°F/149°C) Main Roller Temperature
- Third heated top rear roller for additional processing capabilities (250°F/120°C) Top Rear Roller Temperature
- Rear Table Image Guide
- Single pass over-lamination and transfer processing
- Faster Laminating and Mounting Speed 15 fpm (4.6 mpm)
- Outfeed Slitter System

## 6500 XT BACK CONTROL PANEL

1. **Air Pressure Gauge:** Indicates the PSI reading for the downward pressure of the top pull roller. The standard setting for the normal operation is 35-55 PSI.
2. **Air Regulator Knob:** Adjusts the downward pressure of the top pull roller. Turn clockwise to increase the pressure.
3. **Roller Up/Down Switch (Rear, Top):** Press the switch up to raise the roller. Press the switch down to lower the roller.
4. **Reset Button:** Press this button to reset the material total usage counter to zero. Totalizer Display must be showing to be able to zero out.
5. **Ratometer /Totalizer Button:** Pressing this button will toggle between the roller speed readout or total material usage. Press this button to track and display the total number of feet or meters run in a given period, which can help to monitor film usage. The total will be stored even after the laminator is turned off, and adds to the total whenever the bottom main roller is turning. The corresponding LED will be lit when the Totalizer is being used.
6. **Ratometer/Totalizer Readout:** Displays the rate of speed of the main rollers in either feet or meters per minute, or displays the total number of feet or meters run in a given period.
7. **Top Rear Roller On/Off Button:** Turns On/Off the top rear roller heater. The corresponding LED will be lit when the heater is ON.
8. **Top Rear Roller Temperature Increase Button:** Press this button once to view the temperature set point. Press and hold the button to raise the top rear roller temperature.
9. **Top Rear Roller Temperature Readout:** Displays both the set and actual temperature of the top rear roller.
10. **Top Rear Roller Temperature Decrease Button:** Press this button once to view the set point. Press and hold the button to lower the top rear roller temperature.

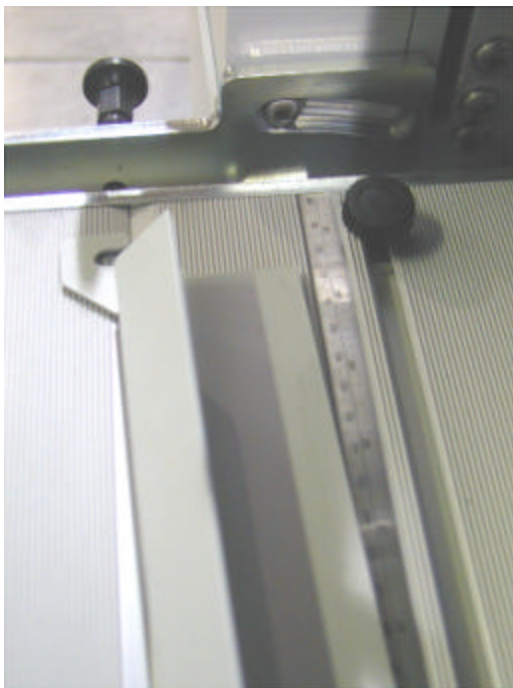


**Figure 1. 6500 XT Top Heat Back Control Panel**

## FEEDING IMAGES

### USING THE IMAGE GUIDE ON THE FLAT TABLE

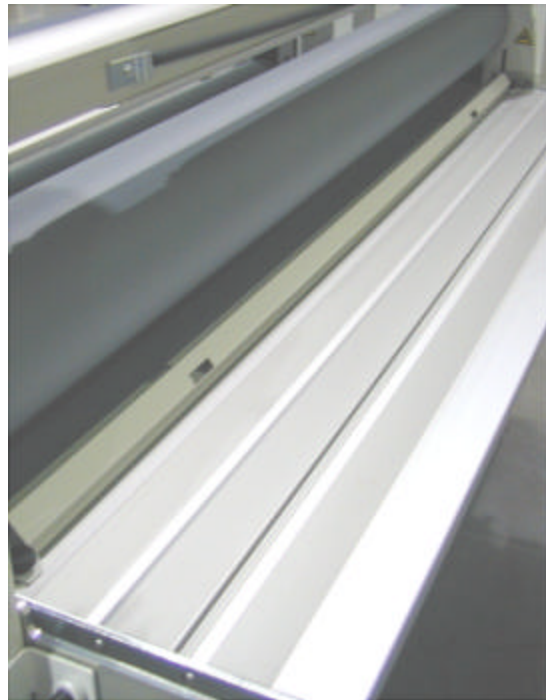
- To aid with feeding in images, the rear table is provided with an “Image Guide”.
- This device can be positioned in front of the roller and it prevents the images from interrupting the photoelectric eyes.
- The image guide can be removed when mounting boards.



***Figure 2. Installing the Rear Table Image Guide***

### POSITIONING THE IMAGE GUIDE ON THE FLAT TABLE

- To position the Image Guide, push it completely in towards the roller aligning the outer notches with the thumbscrews in the table.
- Tighten the thumbscrews down to secure the image guide in place. You are ready to feed images.
- To assist with this, the edge of the image can be seen through the windows in the “Image Guide”, which is in front of the rollers.



***Figure 3. Placement of the Image Guide***

## ONE PASS DRY TRANSFER AND OVERLAMINATE

The One-Pass Dry Transfer process involves transferring an image onto a flexible Marking film and applying an over laminate to the image transfer. Applying the over laminate to the top of the image transfer increases the longevity of your image transfer and allows for outdoor applications. Some types of Transfer Media do not require an over-laminate; please refer to the product literature for recommendations.

### Set-Up for the Transfer Process

**NOTE: Heat-up time is approximately 45 minutes.**

- Refer to the Process Control chart for settings and set the laminator up accordingly.
- NOTE: the cooling tube is in the lower position.

**IMPORTANT! The main roller should be down and turning to prevent uneven hot spots on the roller. A stationary heated roller will develop concentrated heat in one area, which will damage the roller.**

- Once the bottom roller has reached about 140° F (60°C), raise the top roller and every 5 to 10 minutes hand spin the top roller using a soft cloth for skin protection until it reaches the required temperature.

**CAUTION! The top roller is very hot; use care when reaching over or touching the roller to prevent burns.**

- Once the laminator reaches correct operating temperature follow the webbing procedure. Refer to the Webbing Diagram on the corresponding page.

### Webbing for the Transfer Process

- **MARKING FILM (VINYL):** Load and center on the front bottom unwind shaft with the toner receiving side (**shiny side**) **facing out** and the unwind brake tension released.
- Pull a length of film off the bottom unwind shaft and pass it behind the front bottom idler.
- Pull the film forward to feed into the main roller nip. To protect your hands from the heat of the rollers, pull an additional 2 to 3 feet of film, overlapping the film over your hands and feed into the nip area.

- **Rear of the Laminator:** pull the overlapped film through the main roller nip, over the first chill idler and under the second.
- Pull the film through the pull rollers making sure the film is tracking centered through all rollers evenly.
- Pull the film down and tape it securely to a cardboard core placed over the bottom rear take-up shaft. This will automatically wind up the finished product.

**NOTE: Check if the film widths of the lower and upper web are the same!**

- **TRANSFER MEDIA:** Load and center on the front top unwind shaft with the (**toners**) **facing out** and the unwind brake tension released.
- Adjust and align the roll of Transfer Media to the roll of Marking film.
- Pass a length of Transfer Media behind the front top idler, and pull the media forward, again allowing extra to overlap for hand protection from the heated top roller and feed into the nip area.
- **Rear of the Laminator:** pull the overlapped media through the main roller nip, over the first chill idler and under the second.
- Pull the Transfer Media upward, around the rear, top unwind shaft, over the roll of transfer media on the front top unwind shaft and tape it securely to a cardboard core placed over the front top take-up shaft. This will automatically wind-up the media paper after toners have been removed.
- **PRESSURE-SENSITIVE OVERLAMINATE:** Load and center the over-laminate on the rear roll easel shaft aligning it with the finished output.
- Pull the overlamine upward and tape the release liner to a cardboard core placed over the rear top take-up shaft.
- Raise the top rear roller and pass the overlamine over the back of the roller and into the nip.
- Pull the overlamine down to the lower rear take-up shaft and adhere over the Marking film.
- Adjust the web tensions on the unwind and take-up shafts according to the recommended settings.

## TRANSFER PROCESS CONTROL CHART

### MEDIA: Electrostatic Transfer

#### FILMS:

-- -- -- Front Bottom Unwind Shaft: Marking Film (Vinyl)

\_\_\_\_\_ Front Top Unwind Shaft: Transfer Media

. . . . . Roll Easel Shaft: Over-laminate (Optional)

### TRANSFER PROCESS SETTINGS:

#### Front Control Panel

Top Roller Temp.:	300°F (149°C)
Bottom Roller Temp.:	120°F (49°C)
Main Roller Pressure:	85-90 PSI
Cooling Fan:	ON, Under Chill Idlers

#### Back Control Panels

Top Rear Roller Temp.:	Over-laminate Determined
Pull Rollers:	Down
Pull Roller Pressure:	35-40 PSI
Pull Clutch Tension:	40-60 PSI

#### Motor Control Panels

Motor Direction:	Forward
Motor Speed Setting:	1-10 fpm (.3-3.0 mpm)

### Webbing Settings

Web Tension Marking Film:	Light to Medium
Web Tension Transfer Media:	Heavy
Web Tension Over-laminate:	None to Light
Chill Idlers:	Over 1st / Under 2nd
Front Shim Wheel Settings:	-1/16 (-2mm)
Rear Shim Wheel Settings:	-1/16 (-2mm)

**NOTE: The settings are general recommendations. Refer to your media specific Product Literature for their recommended settings.**

**IMPORTANT! We recommend maintaining these temperatures during long runs to ensure the highest-quality output. Do not allow the top roller temperature to drop below 290° F (143° C). Allow the bottom roller to cool down if the temperature exceeds 160° F (71° C) before continuing the process.**

**NOTE: The speed can be adjusted (slower or faster) depending on at what speed you have the best total transfer of the toner into the film.**

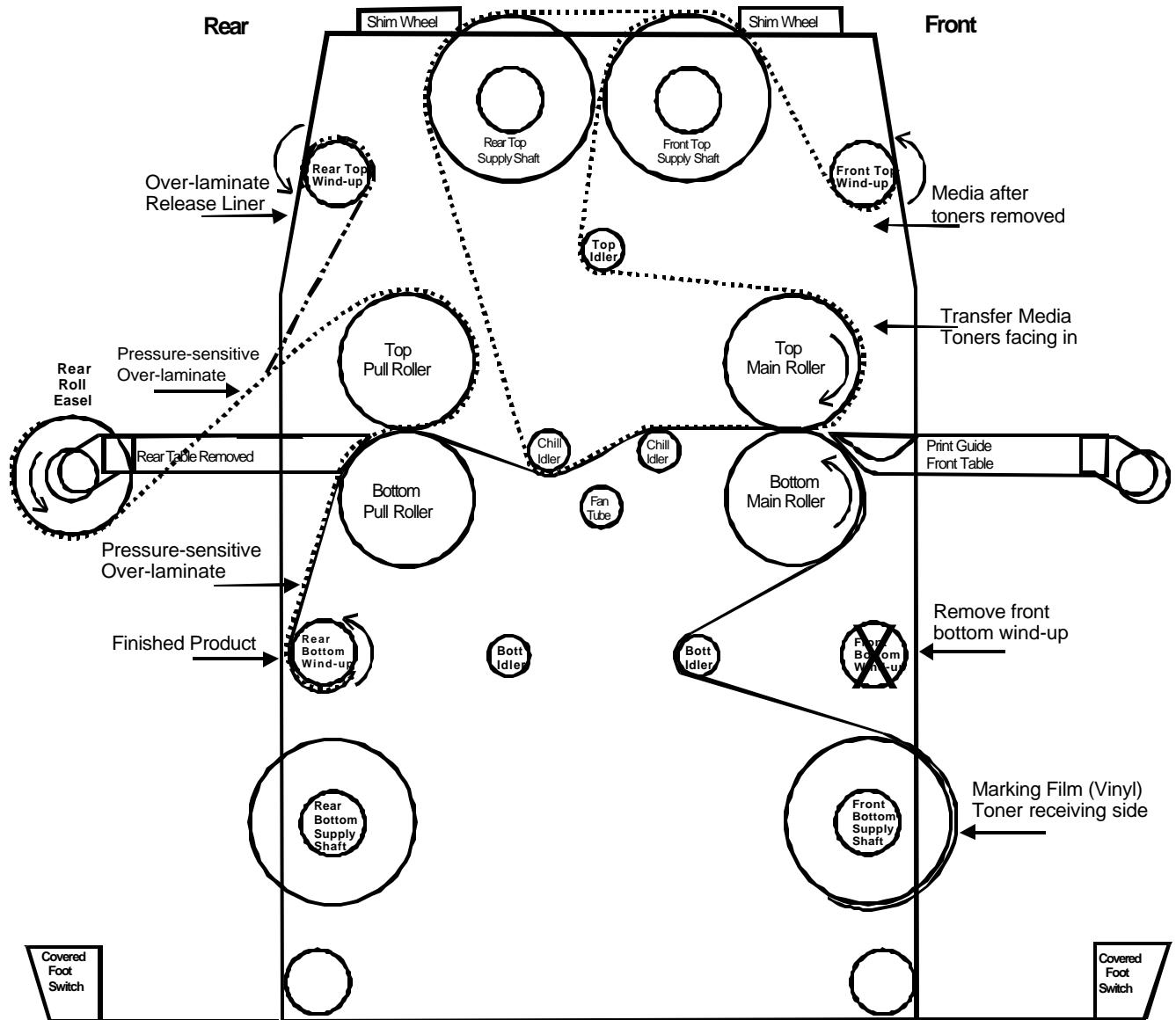
**NOTE: Low temperature heat assist (120° F/49° C) on the Over-laminate will reduce silvering on the final output.**

**NOTE: The clutch tension pressure should not exceed 40 psi. This will prevent excessive pull on the film, affecting the output.**

**NOTE: If you are not applying an over-laminate or prefer to do the transfer as a two-step process (applying the over-laminate in a 2<sup>nd</sup> pass) the toner-removed transfer media can be taken up on the rear, top take-up shaft.**



## TRANSFER PROCESS CONTROL CHART



**Figure 4. Dry Transfer Process Webbing Diagram**

## 6500 XT PROCESS CONTROL CHART

Process: \_\_\_\_\_

Application Use: \_\_\_\_\_

Top Unwind Shaft: \_\_\_\_\_

Bottom Unwind Shaft: \_\_\_\_\_

### Front Control Panel Settings

Top Roller Temp: \_\_\_\_\_

Bottom Roller Temp: \_\_\_\_\_

Main Roller Pressure: \_\_\_\_\_

Cooling Fan: On \_\_\_ Off \_\_\_ Above \_\_\_ Below \_\_\_

### Back Control Panel Settings

Top Pull Roller Temp: \_\_\_\_\_

Pull Rollers: Up \_\_\_\_\_ / Down \_\_\_\_\_

Pull Roller Pressure: \_\_\_\_\_

Pull Clutch Tension: \_\_\_\_\_

**NOTE: We recommend that you make a photocopy of this page. With each successfully run application, record the process and settings and a diagram of the webbing procedure. Keep the record so the application can be repeated at a later date.**

**HINT: If a standard image is made available for each new process then sales materials and samples can be developed for reference.**

### Motor Control Panel Settings

Motor Direction: Forward \_\_\_\_\_ / Reverse \_\_\_\_\_

Motor Speed Setting: \_\_\_\_\_

### Webbing Settings

Chill Idlers: [Over/Under] 1st / 2nd \_\_\_\_\_

Web Tension Top Unwind Shaft:

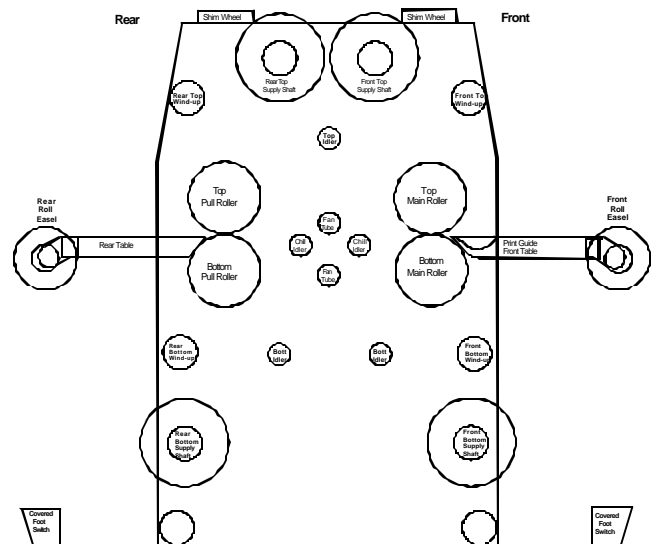
Light \_\_\_\_\_ / Med. \_\_\_\_\_ / Heavy \_\_\_\_\_

Web Tension Bottom Unwind Shaft:

Light \_\_\_\_\_ / Med. \_\_\_\_\_ / Heavy \_\_\_\_\_

Shim Wheel Settings: Front \_\_\_\_\_ / Rear \_\_\_\_\_

Images: Sheet Fed \_\_\_\_\_ / Roll Easel \_\_\_\_\_



**Figure 5. Blank Webbing Diagram**

## 6500 XT TECHNICAL SPECIFICATIONS

### Mechanical

Dimensions (H x W x D)	56" x 85" x 57" (1423 mm x 2159 mm x 1448 mm)
Net Weight	1,710 lbs. (775 kg)
Shipping Weight	2,260 lbs. (1025 kg)
Roller Construction	Four high release silicone-covered rollers

### Process

Max. Working Width	61" maximum (1550 mm)
Max. Roller Speed	15 ft/min. (4.6 m/min.)
Max. Roller Opening	1.75" (44 mm)
Maximum Main Roller Force	42.8 lbs./in. (7.5 N/mm) @ 90 PSI
Maximum Substrate Thickness	1" (25.4 mm)
Nip Settings	0, 1/16, 1/8, 3/16, 1/4, 3/8, 1/2, 3/4, 1 and -1/16" (0, 2, 3, 5, 6, 10, 13, 19, 25 and -2 mm)
Max. Main Roller Temperature	300°F (149°C)
Max. Rear Roller Temperature	250°F (120°C)
Core Inner Diameter	3" (76 mm)

### Electrical

Electrical Requirements	
Single Phase Version	200-240 Vac, 50/60 Hz, 48A, 2/G
Three Phase Version	230-400 Vac, 50/60 Hz, 22A, 3N/PE
Maximum Power consumption	11,000 watts
NOTE: Airborne Noise	Less than 70DB(A)

### Order Codes

SEAL® Image® 6500 XT Single phase	63040
SEAL® Image® 6500 XT International Three phase	63041
SEAL® Image® 6500 XT International Single phase	63042

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Note: SEAL Graphics recommends that your main power be installed by a licensed electrician in accordance with electrical codes in your area. Specifications subject to change without notice.

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